

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021191**Date Inspected:** 01-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

**OBG Segment 14W / Bay 14**

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of FB3343 to BP weld # SEG3020-052. The welder is identified as 045175. ZPMC Quality Control (QC) is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB. See attached photograph Pic\_001.

**OBG Segment 14W / Bay 14**

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of FB3343 to BP weld # SEG3020-056. The welder is identified as 066239. ZPMC Quality Control (QC) is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

**OBG Segment 13AE / Bay 14**

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

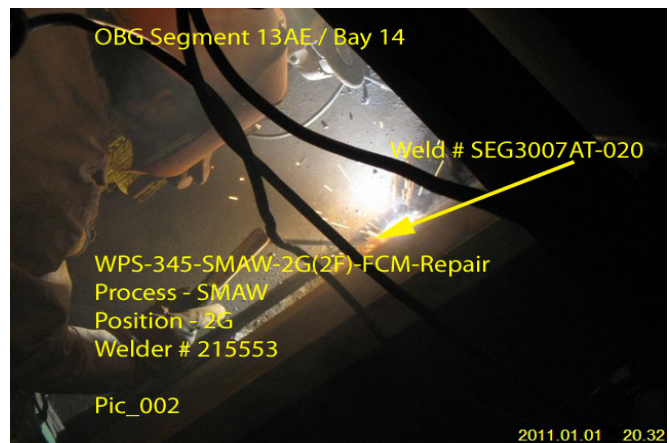
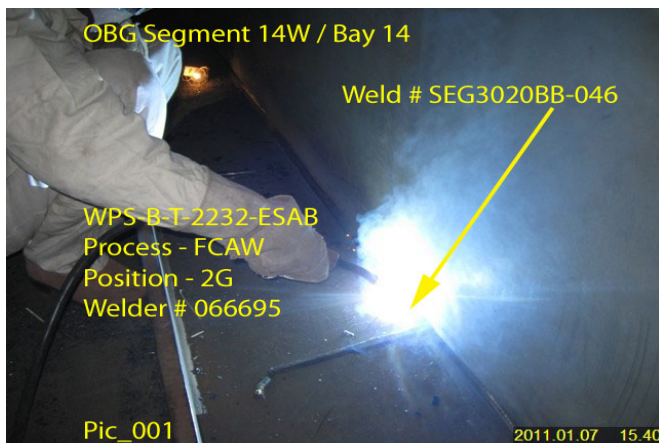
This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of repair weld # SEG3007AT-069, as per B-WR # 19220. The welder is identified as 216086. ABF Quality Assurance (QA) is identified as Yu Jiao. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-FCM-Repair.

OBG Segment 13AE / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of repair weld # SEG3007AT-020, as per B-WR # 19218. The welder is identified as 215553. ABF Quality Assurance (QA) is identified as Yu Jiao. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-FCM-Repair. See attached photograph Pic\_002.



### Summary of Conversations:

No relevant conversations reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Gade,Ramesh	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

---